

Date: Wednesday, 10/11/2006 11:14:32 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: PEDAL ASSEMBLY		
Job Number	: 28929			Part Number	: D412704041		
Estimate Number	: 11005			Drawing Number	: IIN-D412-704 PG6,11		
P.O. Number	: N/A			Project Number	: N/A		
This Issue	: 10/11/2006 S.O. No. : N/A			Drawing Revision	: A		
Prsht Rev.	: NC			Material	: N/A		
First Issue	: N/A Type : SMALL /MED FAB			Due Date	: 10/30/2006 Qty: 4 Um: Each		
Previous Run	: 28642						
Written By							
Checked & Approved By							
Comment							

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 Assemble pedal as per Dwg IIN-D412-704 and Figures 1-3 Note: Only engage one thread on each bolt.		
2.0	PACKAGING 1	PACKAGING RESOURCE #1
<b>Comment:</b> PACKAGING RESOURCE #1 Pick Packing Kit		
3.0	D3204041	Pedal Assembly
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part number Description batch 1 D3204-041 Pedal Assembly B23928		
4.0	D32051	Bracket
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part number Description batch 1 D3205-1 Bracket B28941		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.04.16	1-6	Dwg D412-704-041 SHOULD HAVE BEEN ADDED TO W/O AS PER ECN #911. PROCEED WITH ADDITION OF Dwg.	✓	07.04.16	1	✓ 07.04.16	✓ 070417

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: PEDAL ASSEMBLY

Job Number: 28929

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D32053

Back Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description  
1 D3205-3 GHW Bracket

batch

B2894Z

(PTO)

6.0

D32061

Pedal Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description  
1 D3206-1 Pedal arm

batch

B26153 (3) 28965 CD

7.0

D3209041

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description  
1 D3209-041 Bracket

batch

23194

8.0

AN310A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description  
1 AN3-10A Bolt

batch

H17566

9.0

AN3154R

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description  
1 AN315-4R Nut

batch

H17566

5AD 06:12:10 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
070416	S-0	Part is a bracket. Remove Ground handling → GHW perm. change 2				✓ 070416	✓ 070416

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: PEDAL ASSEMBLY

Job Number: 28929

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0 AN410A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

✓ Qty 1 Part number AN4-10A Description Bolt

batch B17073

11.0 AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

✓ Qty 2 Part number AN4-12A Description Bolt

batch M102380

12.0 AN413A

Bolt



✓ Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

✓ Qty 1 Part number AN4-13A Description Bolt

batch M102380

13.0 AN960JD10

Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

✓ Qty 5 Part number AN960JD10 Description Washer

batch M100743

14.0 AN960JD416

Washer



✓ Comment: Qty.: 11.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

✓ Qty 11 Part number AN960JD416 Description Washer

batch 102339

15.0 AN960JD416L

Washer



✓ Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

✓ Qty 3 Part number AN960JD416L Description Washer

batch M101237

SA1 06:12:16 (u)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services				Drawing Name: PEDAL ASSEMBLY		
Job Number: 28929				Part Number: D412704041		
Job Number: 						
Seq. #:	Machine Or Operation:		Description :			
16.0	MS21042L3		Nut			
						
Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)						
Pick: ✓ 						
Qty	Part number	Description	batch	101917		
3	MS21042L3	Nut				
17.0	MS21042L4		Nut			
						
Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)						
Pick: ✓ 						
Qty	Part number	Description	batch	101917		
5	MS21042L4	Nut		19185		
18.0	MS24694S102		Screw			
						
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)						
Pick: ✓						
Qty	Part number	Description	batch	14609		
1	MS24694S102	Screw				
19.0	MS951910		Bolt			
						
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)						
Pick: ✓						
Qty	Part number	Description	batch	1160290		
1	MS9519-10	Bolt				
20.0	AN960JD10L		Washer			
						
Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)						
Pick: ✓						
Qty	Part number	Description	batch	M101291		
4	AN960JD10L	Washer		SAH 06:12:10 4		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/04/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: PEDAL ASSEMBLY

Job Number: 28929

Part Number: D412704041

Job Number:



Seq. #:	Machine Or Operation:	Description :
21.0	AN36A	Bolt
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)</p>		
<p>Pick:</p>		
Qty	Part number	Description
2	AN3-6A	Bolt
<p>batch <u>18950</u></p>		
<p>✓ <u>07-04-16</u> SAD <u>08-12-16</u> (4)</p>		
22.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
<p>Comment: INSPECT 100% KITS FOR COMPLETENESS</p>		
23.0	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: PACKAGING RESOURCE #1</p>		
<p>Identify and Stock Location: <u>E. Basley/1740</u></p>		
24.0	QC21	FINAL INSPECTION/W/O RELEASE
<p>Comment: FINAL INSPECTION/W/O RELEASE</p>		

Job Completion



W. D. 04-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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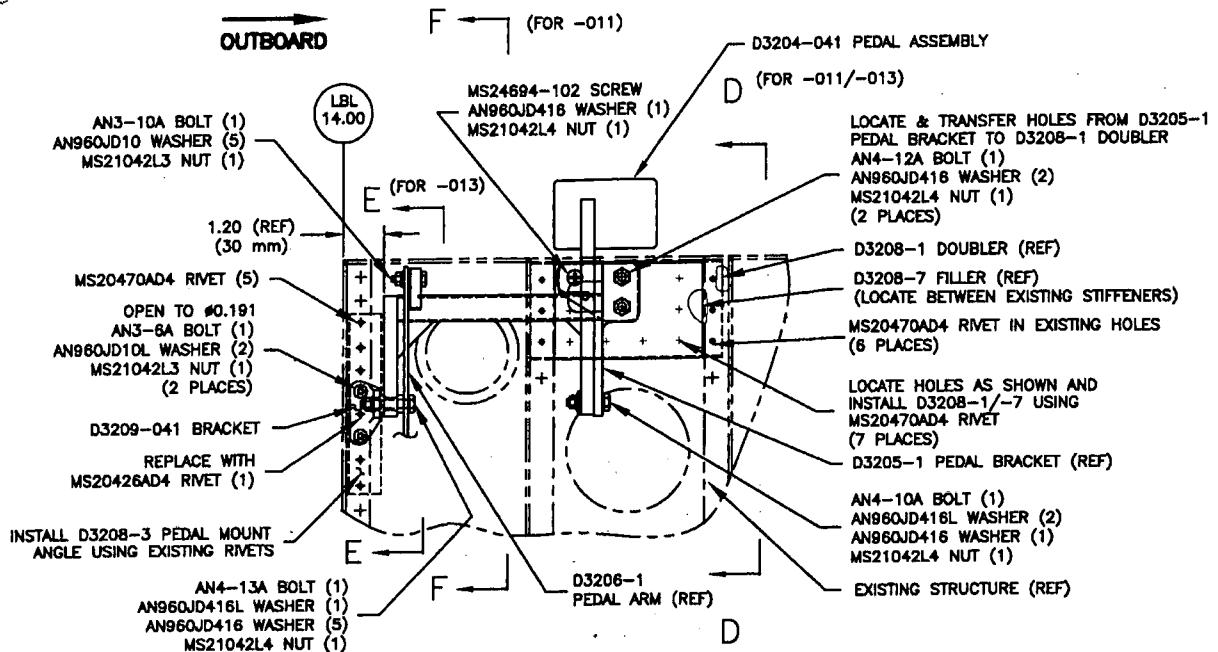
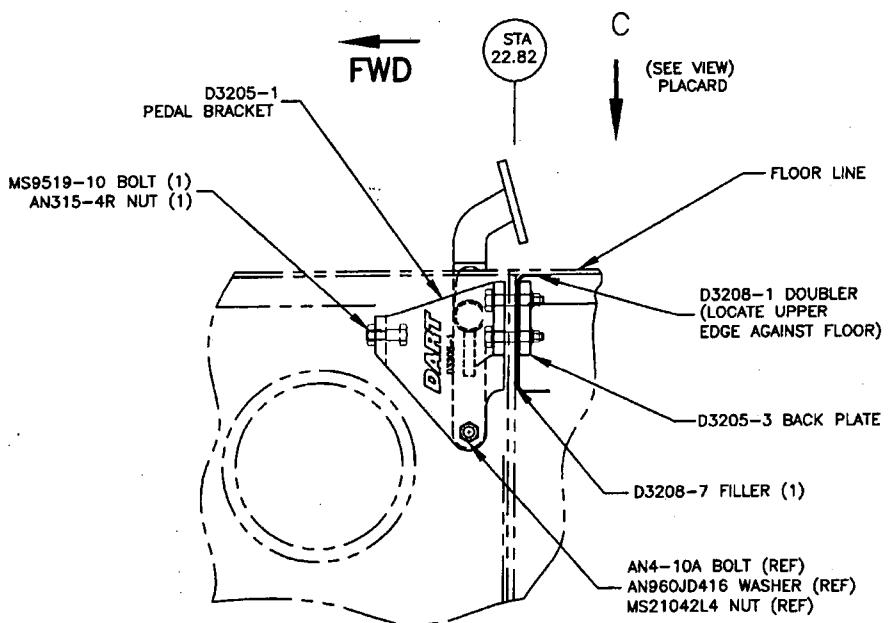


Figure 2 – Detail A. View looking AFT  
(Co-pilot's Side -011/-013 Installations).



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Figure 3 – View D-D. View looking Inboard  
(-011/-013 Installations)

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Revision: A  
Date: 04.02.03

## 5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Qty -043	Qty -045	Part Number	Description
X					D412-704-011	COPilot's EMERGENCY CARGO RELEASE KIT (BELL 212/ 214 / 412)
	X				D205-704-013	COPilot's EMERGENCY CARGO RELEASE KIT (BELL 205)
1	1	X			D412-704-041	PEDAL ASSEMBLY (205/ 212/ 214/ 412)
	1		X		D205-704-043	CABLE ASSEMBLY (205)
1				X	D412-704-045	CABLE ASSEMBLY (212/ 214/ 412)
					D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
					D3205-1	PEDAL BRACKET (OR ECM 999703-1)
					D3205-3	BACK PLATE (OR ECM 999709-5)
					D3206-1	PEDAL ARM (OR ECM 999704-1)
		1			D3207-1	BRACKET
1					D3207-2	BRACKET
	1				D3207-3	BRACKET
1					D3207-5	BRACKET
1	1				D3208-1	DOUBLER (OR ECM 999709-1)
1					D3208-11	FILLER
1	1				D3208-3	PEDAL MOUNT ANGLE (OR ECM 999709-7)
	1				D3208-5	MOUNT ANGLE
1	1				D3208-7	FILLER (OR ECM 999709-3)
1					D3208-9	DOUBLER
		1			D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
1	1				D3214-1	PLACARD (OR ECM 999712-1)
			1		D3217-1	CABLE
				1	D3217-3	CABLE
			1	1	D3257-1	FITTING
				1	D3258-1	ANGLE BRACKET
		1			AN315-4R	NUT
	5	2	2		AN960JD10	WASHER
	4	2	2		AN960JD10L	WASHER
	11				AN960JD416	WASHER
	3				AN960JD416L	WASHER
		3	3		NAS509-3	NUT
	3	2	2		MS21042L3	NUT (OR MS21042-3)
		5			MS21042L4	NUT (OR MS21042-4)
4	4				MS21919DG5	CLAMP
		1			MS24694-S102	SCREW
2					MS35489-10	GROMMET
			1	1	AN3-5A	BOLT
		2			AN3-6A	BOLT
		1			AN3-10A	BOLT
			1	1	AN3-13A	BOLT
		1			MS9519-10	BOLT
		1			AN4-10A	BOLT
		2			AN4-12A	BOLT
		1			AN4-13A	BOLT

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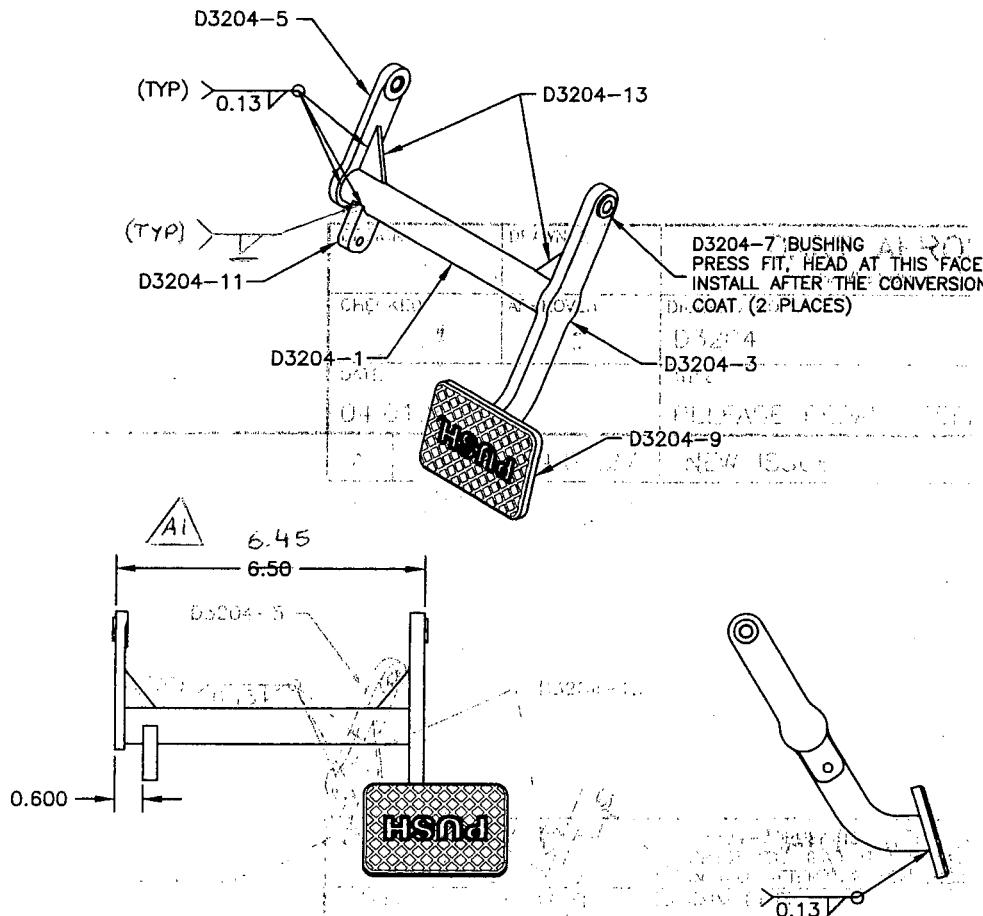
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Revision: A  
Date: 04.02.03

**DART****REFERENCE ONLY**

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3204
DATE		REV. A SHEET 1 OF 3
04.01.27		TITLE RELEASE PEDAL ASSEMBLY
A	04.01.27	SCALE NTS
A1	05.07.15	6.45 WAS 6.50

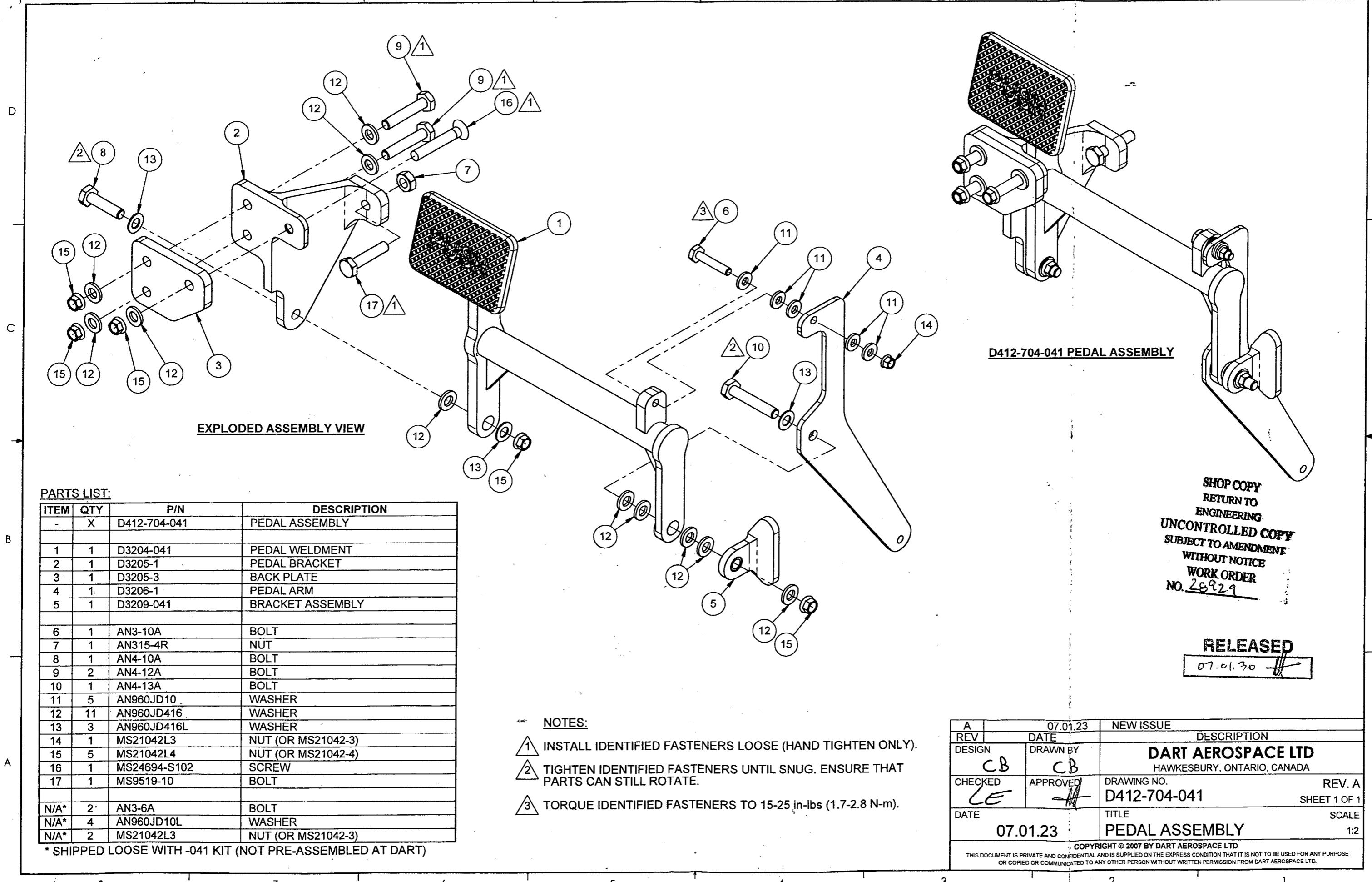
**RELEASED**  
07.04.30**D3204-041 RELEASE PEDAL ASSEMBLY****NOTES**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX. DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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